



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3137-3
Job Sheet 194061



Part No: D3137-3

Job Qty: 30 pcs

Part Name: Guide



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/25/19

Job Tracking No:

Due Date: 5/10/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F IPP Rev:A 02.05.29 New Issue NG IPP Rev:B 08-05-23 revE as per dwg DD verified by:EC IPP
Rev c 08.07.03 ECN1207 EC verified by DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	30 pcs	5/10/19	5/10/19	0.00	0.37	Bandsaw - 1		DJP 19-05-29
110	HAAS 4 Axis - B4B	30 pcs	5/10/19	5/10/19	0.00	7.03	HAAS - 1 - B4B		DJP 19-05-29
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	30 pcs	5/10/19	5/10/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
140	Packaging 3-1 - Stock - B4B	30 pcs	5/10/19	5/10/19	0.00	0.00	Packaging 3 - 1 - B4B		



Container No: S185012



Part: D3137-3

Job No: 194061

Serial No/Batch: S185012

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/29/19

				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	STO1998 JUN 05 2019
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	30 pcs	5/10/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21 JUN 06 2019
				QC 21 - SA - 53	2-55

Part Op **100** - Bandsaw - Cut Blanks. Blank size: 1.250" x .750" x .950" long
 Descriptions: **110** - HAAS CNC Vertical Machine - 1-Machine as per Folio FA242 & Dwg D3137
130 - QC8- Inspect parts - second check
140 - Identify as per dwg & Stock Location: _____
150 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELRLNB0.750X1.250	Delrin Bar	3.0900 ft (103 ea) 2.376 (.0792)	100-Bandsaw - 1	5068422

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MDELRLNB0.750X1.250	3	53	0

2.495
 - 2.376
 Extra 0.119 => Scrap

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Guide	0.175inches $\pm$ 0.010	0.185 0.165		0.174
2	Guide	0.257inches $\pm$ 0.005 -0.000 ^{+0.006} _{-0.001}	0.262 0.257	.263 .256	$\rightarrow$ 0.256
3	Guide	0.650inches $\pm$ 0.010	0.660 0.640		0.660
4	Guide	100Degrees $\pm$ 0	100 100		100°
5	Guide	0.425inches $\pm$ 0.010	0.435 0.415		0.425
6	Guide	0.550inches $\pm$ 0.010	0.560 0.540		0.550
7	Guide	1.100inches $\pm$ 0.010	1.110 1.090		1.102
8	Guide	0.470inches $\pm$ 0.010	0.480 0.460		0.472
9	Guide	0.850inches $\pm$ 0.010	0.860 0.840		0.851
10	Guide	0.143inches $\pm$ 0.010	0.153 0.133		0.140

Plex 4/25/19 11:42 AM Dart.lajeunesse.marie

DAS
73
9-89

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					